



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁶ : B32B 1/00, 3/26, 7/02		A1	(11) International Publication Number: WO 99/50057 (43) International Publication Date: 7 October 1999 (07.10.99)									
<p>(21) International Application Number: PCT/US99/04279</p> <p>(22) International Filing Date: 29 March 1999 (29.03.99)</p> <p>(30) Priority Data:</p> <table> <tr> <td>60/080,014</td> <td>30 March 1998 (30.03.98)</td> <td>US</td> </tr> <tr> <td>60/090,011</td> <td>19 June 1998 (19.06.98)</td> <td>US</td> </tr> <tr> <td>09/273,107</td> <td>19 March 1999 (19.03.99)</td> <td>US</td> </tr> </table> <p>(71) Applicant: HENKEL CORPORATION [US/US]; Suite 200, 2500 Renaissance Boulevard, Gulph Mills, PA 19406 (US).</p> <p>(72) Inventor: WYCECH, Joseph, S.; 795 Hidden Lane, Grosse Pointe Woods, MI 48236 (US).</p> <p>(74) Agent: WISDOM, Norvell, E., Jr.; Henkel Corporation, Suite 200, 2500 Renaissance Boulevard, Gulph Mills, PA 19406 (US).</p>		60/080,014	30 March 1998 (30.03.98)	US	60/090,011	19 June 1998 (19.06.98)	US	09/273,107	19 March 1999 (19.03.99)	US	<p>(81) Designated States: AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CU, CZ, DE, DK, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, UA, UG, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG).</p> <p>Published <i>With international search report.</i></p>	
60/080,014	30 March 1998 (30.03.98)	US										
60/090,011	19 June 1998 (19.06.98)	US										
09/273,107	19 March 1999 (19.03.99)	US										
<p>(54) Title: REINFORCEMENT LAMINATE</p> <p>(57) Abstract</p> <p>A tri-laminate body panel stiffener (4) includes two polymer layers (5, 6) with or without abacking (7). One of the layers is a compliant foam layer (5) mounted against a substrate (1) while the other layer is a rigid foam layer (6) mounted against the compliant foam layer (5). In another aspect of the invention the laminate comprises a backing member having an expandable foam mounted thereto with two or more edges of the laminate being of non-straight construction such as being wavy or saw tooth. A pattern of holes may be formed through the foam and backing layers.</p>												

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece	ML	Mali	TR	Turkey
BG	Bulgaria	HU	Hungary	MN	Mongolia	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MR	Mauritania	UA	Ukraine
BR	Brazil	IL	Israel	MW	Malawi	UG	Uganda
BY	Belarus	IS	Iceland	MX	Mexico	US	United States of America
CA	Canada	IT	Italy	NE	Niger	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NL	Netherlands	VN	Viet Nam
CG	Congo	KE	Kenya	NO	Norway	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NZ	New Zealand	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	PL	Poland		
CM	Cameroon	KR	Republic of Korea	PT	Portugal		
CN	China	KZ	Kazakhstan	RO	Romania		
CU	Cuba	LC	Saint Lucia	RU	Russian Federation		
CZ	Czech Republic	LI	Liechtenstein	SD	Sudan		
DE	Germany	LK	Sri Lanka	SE	Sweden		
DK	Denmark	LR	Liberia	SG	Singapore		
EE	Estonia						

REINFORCEMENT LAMINATE

Background of the Invention

The conventional practice to stiffen outer automotive body panels is with
5 a sheet thermoset polymer placed on the inside of a panel and then heat cured in a paint
oven. The conventional heat cured stiffener is applied as a wallpaper sheet type applique
or as a sprayed on layer. The applique is provided in a single or double layer sheet. The
main layer is a thermoset layer with or without a backing. Where a backing is used, the
backing can be fiberglass cloth, metal screen, or foil. The spray on is a single polymer
10 layer without a backing. The polymer layer is generally 0.020 to 0.100 inches thick.

In the automotive industry when the vehicle doors are painted during heat
cure there is a problem with paint read through due to the heat curing of the outer metal
body panel stiffener and the expansion and contraction of the metal outer panel during
the paint bake cycle. It would be desirable if some techniques could be provided to
15 eliminate or reduce the paint read through problem.

Summary of the Invention

An object of this invention is to provide a body panel stiffener which
improves upon the conventional practices.

20 A further object of this invention is to eliminate paint shadowing or metal
distortion by reducing the cure shrinkage strains during the polymer cure and metal panel
curing.

A still further object of this invention is to provide such techniques which
are particularly adaptable for the automotive industry.

In accordance with one aspect of this invention a laminate body panel reinforcement or stiffener is provided which includes two polymer layers mounted against a substrate with or without a backing. Preferably, one of the polymer layers is a compliant foam which would be disposed directly against the substrate or structural member being reinforced. An outer or rigid foam layer is secured to the other side of the compliant foam layer and a carrier, such as a foil or fibreglass backing is secured to the outer surface of the rigid foam layer.

In accordance with another aspect of this invention the reinforcing laminate for a part or substrate is made from a stiffener member or backing having an expandable foam secured thereto. In accordance with the invention read through is controlled by various alternative techniques. For example, the read through can be controlled by having no parallel longitudinal edges. This can be achieved by having either wavy and/or saw tooth conditions on two and/or four opposing edges. A further technique to control read through would be by the material polymer thickness and by 15 punching or forming holes through all the polymer and backing layers. The hole pattern can be ordered or uniform or can be in a staggered or a random display.

Brief Description of the Drawings:

Figures 1 and 2 are cross-sectional views in elevation of prior art stiffeners;

20 Figure 3 is a cross-sectional view in elevation of a tri-laminate body panel stiffener in accordance with this invention;

Figure 4 is a perspective view showing the stiffener of Figure 3 used for automobile door application;

Figures 5-7 are cross-sectional views of various configurations based on the section A-A of Figure 4;

Figure 8 is a side elevational view showing the inside of a vehicle door having a reinforcement laminate mounted thereto in accordance with a further aspect of this invention;

Figure 9 is a cross-sectional view taken through Figure 8 along the line 9-9:

Figure 10 is a front elevational view of one form of reinforcement laminate; and

10 Figure 11 is a view similar to Figure 10 of a modified form of reinforcement laminate.

Detailed Description

15 Figures 1-2 illustrate conventional practices for stiffening outer automotive body panels. As shown therein a metal substrate 1 is provided on which a polymer 2 is attached. The application of the polymer 2 which can be a sheet thermoset polymer can be by using a wallpaper sheet type technique as shown in Figure 1 or can be sprayed on as shown in Figure 2. In the practice shown in Figure 1 a fiberglass backing 3 covers the polymer 2. After the polymer 2 is applied it is then heat cured in an oven. Where a wallpaper sheet type applique is used, a single or double layer sheet may be applied. The main layer would be a thermoset layer with or without a backing. In the alternative of Figure 2 a single polymer layer is applied without a backing. Where a backing is used the backing can be fiberglass cloth, metal screen, or foil. Generally, the polymer layer would have a thickness of 0.020 to 0.100 inches thick.

20

The conventional panel stiffeners such as shown in Figures 1 and 2 shrink

when they cure. Because of their good adhesion, the cure shrinkage strains are fed into the substrate 1 to which the stiffener is bonded. Consequently, paint on the opposite face of substrate 1 would be patterned according to the induced strains in the substrate.

5 Figure 3 illustrates a stiffener 4 in accordance with this invention. As shown therein a compliant foam layer 5 is applied directly against the panel or metal substrate 1. A rigid foam layer 6 is applied against the compliant foam layer 5. Figure 3 also illustrates a foil or fiberglass backing or carrier 7 on the outer surface of rigid foam layer 6. This results in a tri-laminate body panel stiffener 4.

10 When the tri-laminate stiffener 10 cures the first intimate layer 5 can not transfer shrinkage strains to the substrate 1 and layer 5 cannot restrain the outer metal panel from shrinking when the panel comes out of the oven because it is not rigid after cure. The second layer 6 is rigid after cure but its shrinkage strain are blocked from getting to the substrate by the compliant first layer. The backing or carrier 7 is used to provide additional stiffness.

15 The compliant foam layer 5 absorbs shrinkage strains due to the cure of the heat curable layers. Large shrinkage strains of the rigid layer 6 are not fed in the metal substrate 1 but yet the rigid layer 6 with its backing 7 will stiffen the panel. A typical layer thicknesses are from 1-1.5 mm for compliant layer 5 and 1-2.0 inches for rigid layer 6 with backing layer 7 having a thickness of 0.002-0.004 inch. Any suitable materials may be used for layers 5 and 6. Both polymer layers should be compatible in chemistry, however, otherwise the cured finished product of either layer will be compromised. Reference is made to my U.S. Patent No. 5,575,526 and my application Serial No. 09/099,025, filed June 17, 1998, all of the details of which the patent and application and incorporated herein by reference thereto. The patent and application

disclose suitable materials which may be used for the foam layer to create a rigid structural foam and materials for the carrier. The specific materials are not critical provided they function in the intended manner, namely, in that the layer 5 would be compliant while the layer 6 would have rigidity. Compliant layer 5 may have rubber-like 5 characteristics such as materials conventionally used for refrigerator door seals or automobile door strips. Layer 5 may be tacky or non-tacky.

Figure 4 illustrates the foil back laminate 4 of this invention as used for automobile door application. Figures 5-7 illustrate in cross-section different possible configurations for such applications. As is apparent from Figures 3 and 5, the tri-polymer 10 layer stiffener 4 may be of uniform thickness with flat planar layers as illustrated in Figure 3.

Figure 5, however, illustrates a door panel 1 to have a shallow curve configuration. The patch or stiffener 4 would conform to that configuration. Figure 5 shows the stiffener 4 to have uniform thickness. Figures 6-7, however, show variations 15 which could be incorporated which would require non-uniform thickness. As shown, the foil backing or carrier 7 includes an outer channel section 7A forming a rib or bead in combination with the extended portion 8 of the foam layers 5,6. The foam layers 5,6 could be provided as two separate pairs of sheets which abut against each other in the channel section 7A. For example, Figure 6 shows the two foam layers 5 to abut each 20 other at surface 5A. Foil backing 7 may also be made of two layers which abut at the center of channel 7A.

Figure 7 shows end extensions or flanges 7B for the foil backing 7 with conforming end flanges 9 for the pair of foam layers 5,6 in combination with a central extension 7C of the foil backing 7 and a central extension 9A of the foam layers 5,6 to

accommodate a rib 1A on the panel 1. The provision of these outward extensions results in rib sections that offer even more panel stiffening than a completely flat and/or uniform laminate because of the increase in section and redistribution of the foil backed laminate reinforcement away from the panel neutral axis. Thus, Figures 6-7 illustrate the stiffener 5 4 to include stiffening beads while Figure 7 also includes stiffening end flanges.

Figures 8-11 relate to another aspect of this invention which is intended to address problems relating to paint read through which cause shadowing or metal distortion. The techniques involved in Figures 8-11 may be used in combination with the tri-laminate structure of Figures 3-7 or may be used separately from those features.

10 In general, the invention illustrated in Figures 8-11 includes providing a laminate stiffener or reinforcement laminate for a part or substrate. The materials of the laminate and of the substrate to which it would be applied and the uses of the invention may be those discussed with respect to Figures 3-7.

15 As shown in Figures 8-9 the part or substrate 10 being reinforced is a vehicle door. A reinforcement laminate 12 is mounted to the door preferably at generally the central area of the door. The laminate may be of any suitable size and shape. In the preferred embodiment the laminate is of generally rectangular shape having certain modifications which will be later discussed. Laminate 12 comprises a backing 14 and an intimately bonded expandable foam layer 16. Foam layer 16 may be a single rigid 20 structural foam layer such as in my previously noted patent and application or may be of two layer form as illustrated, for example, in Figure 3. Layer 16 is disposed against the substrate 10. Where the invention is used in the automotive industry Figure 9 schematically shows a paint spray nozzle 18 applying a pattern of paint 20 to create a paint layer 22 on the substrate 10. Where part 10 is in a paint oven in which the polymer

16 cures, there might be a problem with paint read through of the heat cured outer metal panel body stiffeners. The present invention provides various techniques for eliminating or reducing such paint read through.

Figure 10 illustrates one practice of the invention where the laminate has a pair of longitudinal side edges 26,26 interconnected by a pair of transverse end edges 24,24. As shown therein the opposed end edges 24,24 are of non-straight linear configuration forming hills and valleys. Specifically, in the embodiment illustrated in Figure 10 the edges 24,24 are of saw tooth construction. Intermediate edges 26,26 are illustrated as being straight edges parallel to each other. It is to be understood, however, that edges 26,26 may also be of non-straight shape such as having saw-tooth construction so that all four edges have peaks and valleys. Alternatively, edges 26,26 may have the saw tooth construction and edges 24,24 may be straight parallel edges.

Figure 11 illustrates a variation wherein the longitudinal edges 28,28 have peaks and valleys by being undulated or wavy. The intermediate edges 30,30 are illustrated as being straight and parallel. The invention, however, may be similarly practiced where edges 30,30 are also of wavy construction similar to edges 28,28 or where the wavy construction is on edges 30,30, but edges 28,28 are straight and parallel.

Figure 8 illustrates the further possibility of saw-tooth edges 24 and wavy edges 28. Thus, any arrangement of creating peaks and valleys may be used within the broad practices of this invention including different forms of structure to achieve the peaks and valleys along different edges.

In accordance with a further practice of the invention read through is controlled by the material polymer thickness and by punching or otherwise forming holes through all of the polymer and backing layers. Figure 10, for example, shows a pattern

of holes 32 in a uniform or ordered array where all of the holes are arranged in straight rows and columns in line with each other. Figure 11, however, shows the holes 34 to be in straight rows and columns which are staggered. The invention may also be practiced where the holes are in a random pattern, rather than straight rows and columns.

5 Where holes are provided through the laminate 12, the laminate may optionally include the non-straight edges such as the saw tooth and wavy formations or optionally the laminate could have some or all of the edges straight.

The invention may be practiced by forming the backing layer 14 of the desired shape which includes the non-straight edges. The polymer or unexpanded foam 10 may then be coated on or otherwise applied to the entire surface of backing 14 to form the laminate 12. The laminate 12 would then be mounted to substrate 10 by positioning the polymer layer 16 against the substrate 10. When the polymer is activated, the foam expands and would move backing layer 14 outwardly further away from substrate 10. The foam would also expand outwardly beyond the edges of backing 14. The various 15 techniques used for practicing the invention would result in reducing or eliminating paint shadowing or metal distortion by reducing shrinkage strains during the polymer cure. While the invention is preferably practiced with a heat expandable polymer the invention may also be practiced with other types of expandable polymers, such as chemically activated as in the above noted application.

20 Although the invention has been particularly described with respect to its preferred use for reinforcing vehicle doors the concept of the invention may be applied for reinforcing other parts. For example, the invention may be used for roofs, deck lids and fenders of vehicles. The invention may also be used for reinforcing non-vehicle parts. Similarly, while the invention is preferably practiced for supporting a metal

substrate, other substrates may be used as disclosed in the above noted applications. The backing 14 is preferably a thin metal foil such as an aluminum foil. The invention may be practiced, however, with other backing materials such as described in the above noted applications.

5 The provision of the various techniques for controlling paint through may be incorporated in stiffening reinforcements which include the added features of the above noted applications or which are simply part of a basic structure comprising a backing and foam laminate.

 The various features described in detail herein may be used in combination 10 with each other or separately from each other and may also be used in combination with the features described in my co-pending application Serial No. 09/099,025.

What is Claimed is:

A reinforcement laminate for reinforcing a substrate comprising a carrier layer, a layer of rigid reinforcement foam secured to said carrier layer, a layer of compliant foam secured to said rigid foam, said layer of compliant foam comprising a bonding layer for 5 securing said laminate to a substrate, said rigid foam layer and said compliant foam layer being heat curable, and said compliant foam layer comprising means for absorbing shrinkage strains due to heat cure of said foam layer and cooling of the substrate.

The laminate of claim 1 wherein said carrier layer is a foil backing.

The laminate of claim 1 in combination with said substrate, and said compliant 10 foam being intimately bonded to said substrate.

The laminate of claim 3 wherein said foam layers and said carrier layer include at least one rib.

The laminate of claim 4 wherein said substrate includes a rib in line with said rib of said foam layers and said carrier layer.

15 The laminate of claim 5 wherein said foam layers and said carrier layer include end flanges.

The laminate of claim 3 wherein said substrate is a vehicle part selected from the group consisting of a door, a roof, a deck lid and a fender.

The laminate of claim 1 wherein said laminate has a pair of longitudinal side 20 edges interconnected by a pair of transverse end edges and at least one of said pair of side edges and said pair of end edges is of non-straight and undulated shape.

The laminate of claim 8 wherein said undulated shape has a pattern of hills and valleys joined together in a smooth wavy pattern.

The laminate of claim 8 wherein said undulated shape has a pattern of hills and 25 valleys in a sawtooth shape.

The laminate of claim 8 wherein said non-straight and undulated edges are said side edges.

The laminate of claim 8 wherein said non-straight and undulated edges are said end edges.

5 The laminate of claim 12 wherein said side edges are also non-straight and undulated.

The laminate of claim 8 including a pattern of holes completely through said laminate.

10 The laminate of claim 14 wherein said pattern of holes comprises a plurality of uniformly and equally spaced aligned rows and columns of holes.

The laminate of claim 14 wherein said pattern of holes comprises a plurality of holes arranged in staggered rows and columns.

The laminate of claim 14 wherein said pattern of holes is randomly arranged.

15 The laminate of claim 8 in combination with said substrate, and said compliant foam layer being intimately bonded to said substrate.

The laminate of claim 18 wherein said substrate is an automobile door.

20 A reinforcement laminate for reinforcing a substrate comprising a carrier layer, an expandable foam layer intimately bonded to said carrier layer to form a reinforcing unit, said reinforcing unit having a pair of longitudinal side edges interconnected by a pair of transverse end edges, and at least one of said pair of side edges and end edges being non-straight and undulated.

The laminate of claim 20 wherein said undulated shape has a pattern of hills and valleys joined together in a smooth wavy pattern.

25 The laminate of claim 20 wherein said undulated shape has a pattern of hills and valleys in a sawtooth shape.

The laminate of claim 20 wherein said non-straight and undulated edges are said side edges.

The laminate of claim 20 wherein said non-straight and undulated edges are said end edges.

5 The laminate of claim 20 wherein said side edges are also non-straight and undulated.

The laminate of claim 20 including a pattern of holes completely through the laminate.

The laminate of claim 26 wherein said pattern of holes comprises a plurality 10 of uniformly and equally spaced aligned rows and columns of holes.

The laminate of claim 26 wherein said pattern of holes comprises a plurality of holes arranged in staggered rows and columns.

The laminate of claim 26 wherein said pattern of holes is randomly arranged.

The laminate of claim 20 in combination with said substrate, and said foam 15 layer being intimately bonded to said substrate.

The laminate of claim 30 wherein said substrate is an automobile door.

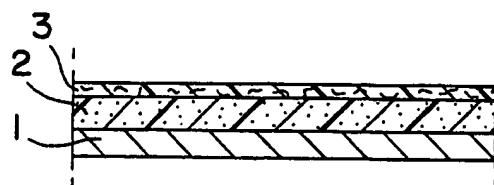


FIG. 1
PRIOR ART

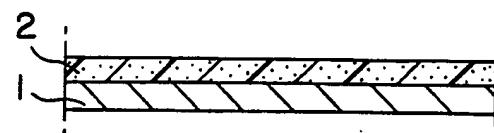


FIG. 2
PRIOR ART

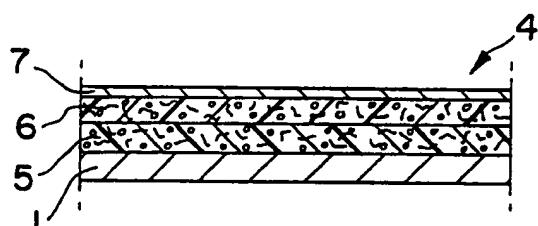


FIG. 3

2/3

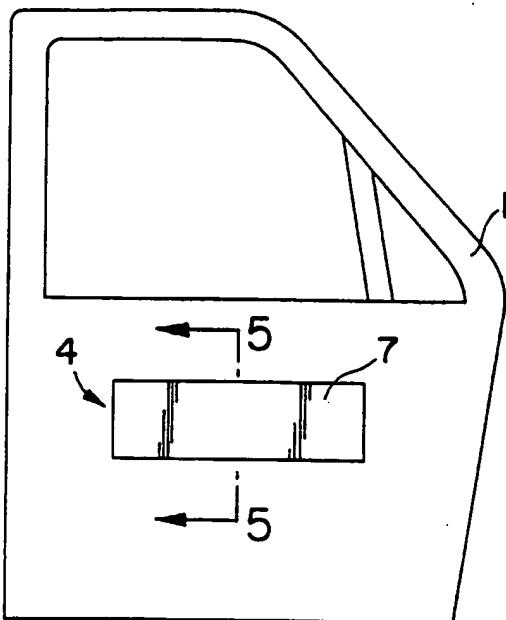


FIG. 4

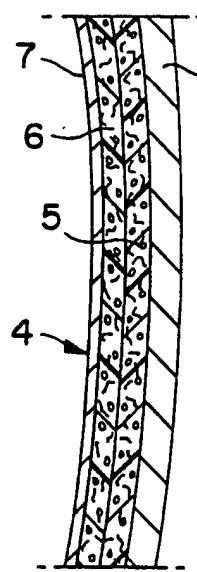


FIG. 5

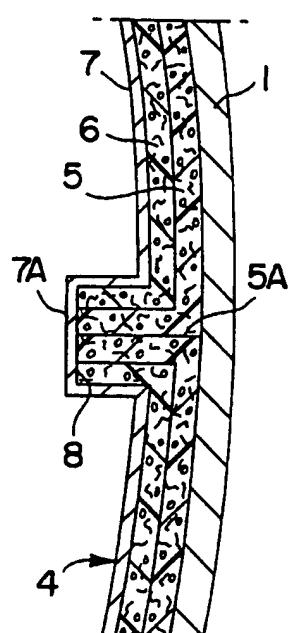


FIG. 6

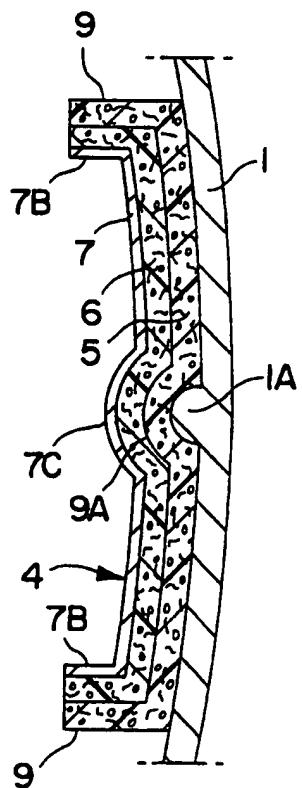


FIG. 7

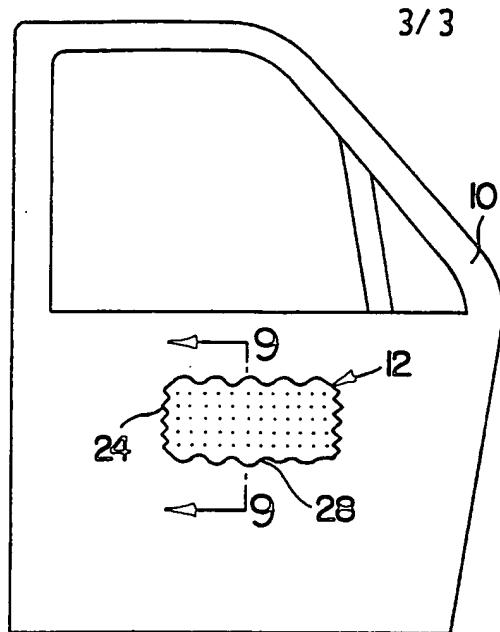


FIG. 8

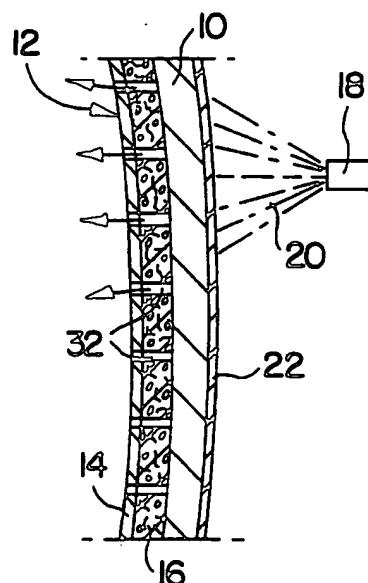


FIG. 9

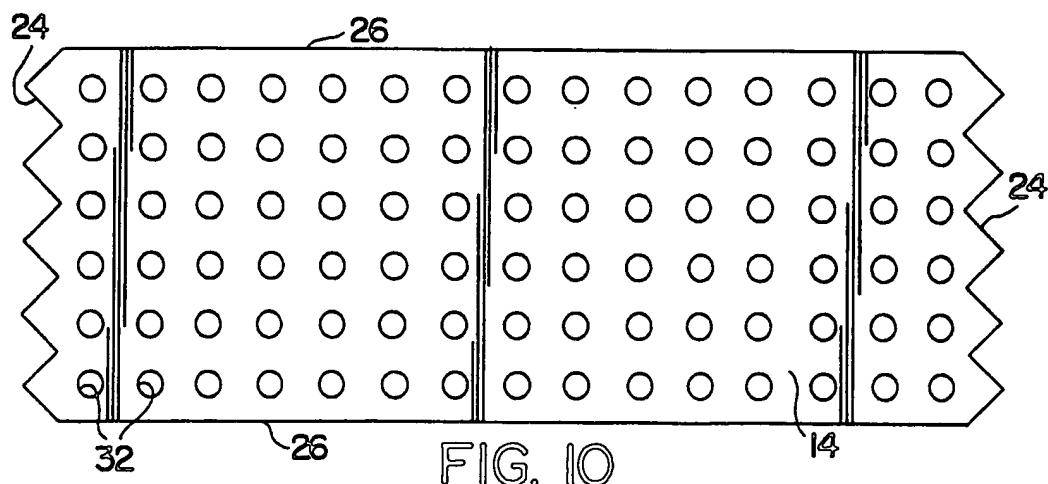


FIG. 10

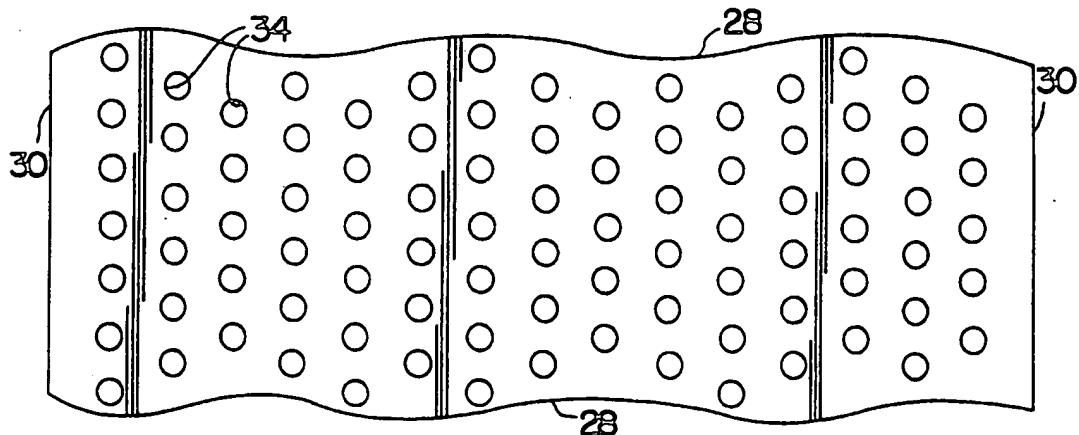


FIG. 11

INTERNATIONAL SEARCH REPORT

International application No.

PCT/US99/04279

A. CLASSIFICATION OF SUBJECT MATTER

IPC(6) :B32B 1/00, 3/26, 7/02

US CL :428/119, 177, 192, 218, 316.6, 317.1, 319.1

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

U.S. : 428/119, 177, 192, 218, 316.6, 317.1, 319.1

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

NONE

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

NONE

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 5,215,796 A (MUELLER et al) 01 June 1993 (01-06-93), see entire document.	1, 3-6, 8-14, 18, 20-25, 30
--A		2, 7, 15-17, 19, 26-29, 31
X	US 5,073,429 A (STEINKE et al) 17 December 1991 (17-12-91), see entire document.	20-25, 30, 31
--A		— 1-19, 26-29
X	US 4,042,746 A (HOFER) 16 August 1977 (16-08-77), see entire document.	1-3

Further documents are listed in the continuation of Box C. See patent family annex.

• Special categories of cited documents:	"T"	later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention
•A• document defining the general state of the art which is not considered to be of particular relevance	"X"	document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone
•B• earlier document published on or after the international filing date	"Y"	document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art
•L• document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)	"Z"	document member of the same patent family
•O• document referring to an oral disclosure, use, exhibition or other means		
•P• document published prior to the international filing date but later than the priority date claimed		

Date of the actual completion of the international search

01 JULY 1999

Date of mailing of the international search report

15 JUL 1999

Name and mailing address of the ISA/US
Commissioner of Patents and Trademarks
Box PCT
Washington, D.C. 20231

Facsimile No. (703) 305-3230

Authorized officer

BLAINE R. COPENHEAVER

Telephone No. (703) 308-0661

INTERNATIONAL SEARCH REPORT

International application No.
PCT/US99/04279

C (Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 3,919,443 A (PORTER) 11 November 1975 (11-11-75), see entire document.	20, 23-25, 30 ----
--		
A		21, 22, 26-29, 31